

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020418**Date Inspected:** 21-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Gang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Structure**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 -14AE

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3019-E-1-179.Located on SEG3019-E-1. The welder is identified as 062782. ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

BAY 14- 13AE

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007C-260 .Located on SEG3007C. The welder is identified as 044795. ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FLUX CORED ARC WELDING (FCAW)

WELDING INSPECTION REPORT

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This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007AV-005 .Located on SEG3007AV. The welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007AV-009 .Located on SEG3007AV. The welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007AV-104 .Located on SEG3007AV. The welder is identified as 066733. ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

IN PROCESS VISUAL INSPECTION

This QA Inspector Mr. Manuel Teall performed a preliminary random visual inspection on OBG Segment 14AE and found that an area of Weld previously gouged by ZPMC had Melt Through measuring approximately 10mm in length.

The weld is identified as SEG3019D-1-179 .

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Teall,Manuel	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
